

# Work Order ID 105596

\*105596\*

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Item ID: D2695-2 Accept \*N900040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Leg  
 Start Date: 8/08/13 Start Qty: 1.00 \*1\* Cust Item ID:  
 Required Date: 8/08/13 Req'd Qty: 1.00 \*1\* Customer:  
 Reference: RE-POWDERCOAT *Rework*

Approvals: Process Plan: *[Signature]* Date: Tooling: Date: Run Start \*NR1\*  
 QC: Date: SPC (Y/N): Date: Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2695	Rev C								

140 Chemical Conversion Coat per QSI005 4.1 0.00  
 \*140\*  
 HandFinish Memo 0.00  
 Hand Finishing PULL FROM STK:  
 1 X D2695-2 B15057  
 STRIP COMPLETELY  
 RE-ALODINE

150 Black Sandtex (Ref:4.3.5.7) per QSI005 4.3 0.00  
 \*150\*  
 Powdercoat Memo 0.00  
 Powder Coating REPOWDERCOAT WHITE PER QSI005  
 START TIME: 8:30 OVEN TEMPERATURE:  
 FINISH TIME: 9:00

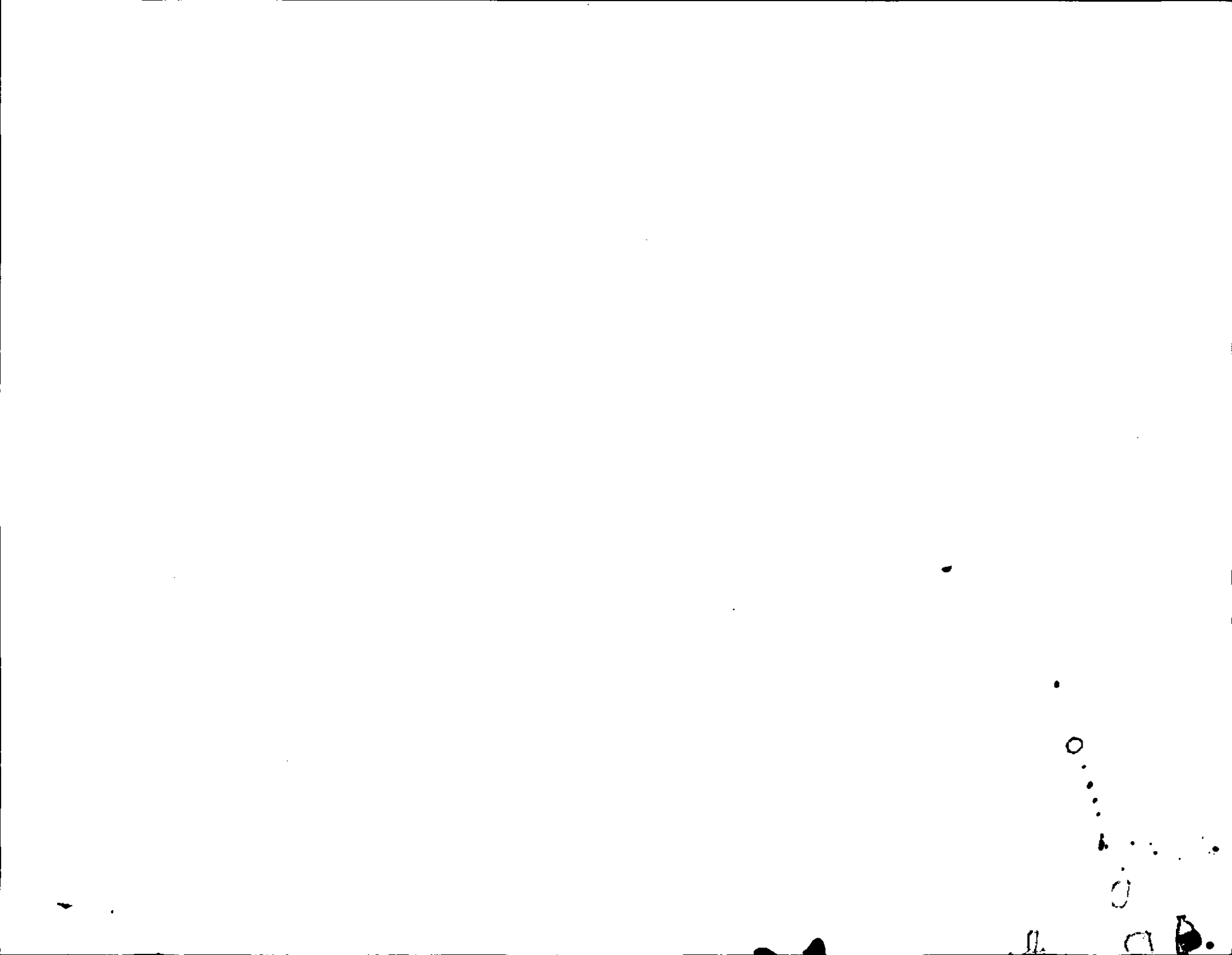
160 QC3- Inspect Part Finish 0.00  
 \*160\*  
 QC Memo 0.00  
 Quality Control

*W12625*

*1X y m-13/08/14*

*1X d ll 13/08/14*

*DAS 05 13-08-13*



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 Required Date: 8/08/13 Req'd Qty: 1.00 \*1\* Customer:  
 Reference: RE-POWDERCOAT

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	Identify as per dwg & Stock Location: <u>ST 230</u>	0.00							
*170*									
Packaging	Memo	0.00							
Packaging	REIDENTIFY USING NEW B.N								
180	QC21- Final Inspection - Work Order Release	0.00							
*180*									
QC	Memo	0.00							
Quality Control									

1X  
 13-8-15  
 13/8/20  
 MLS 13-08-15



# Picklist Print

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Work Order ID: 105596

Parent Item: D2695-2

Parent Item Name: Leg

Start Date: 8/08/13

Required Date: 8/08/13

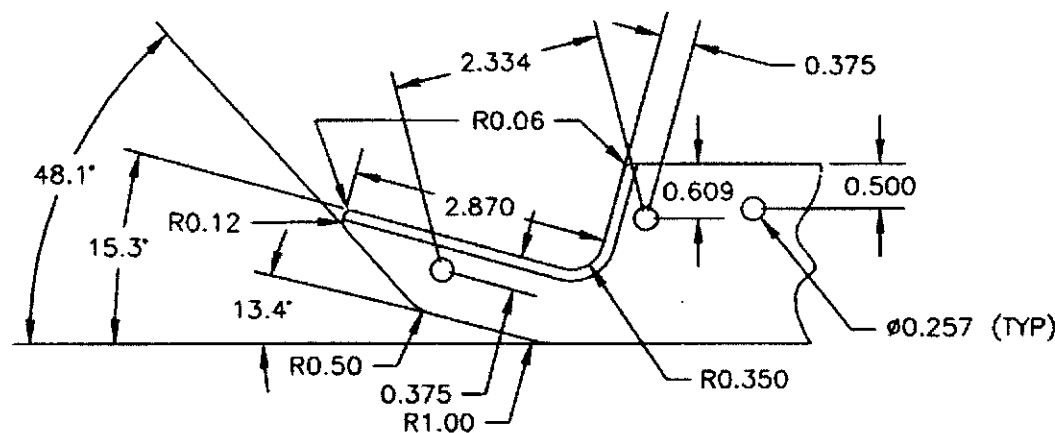
Start Qty: 1.00

Required Qty: 1.00

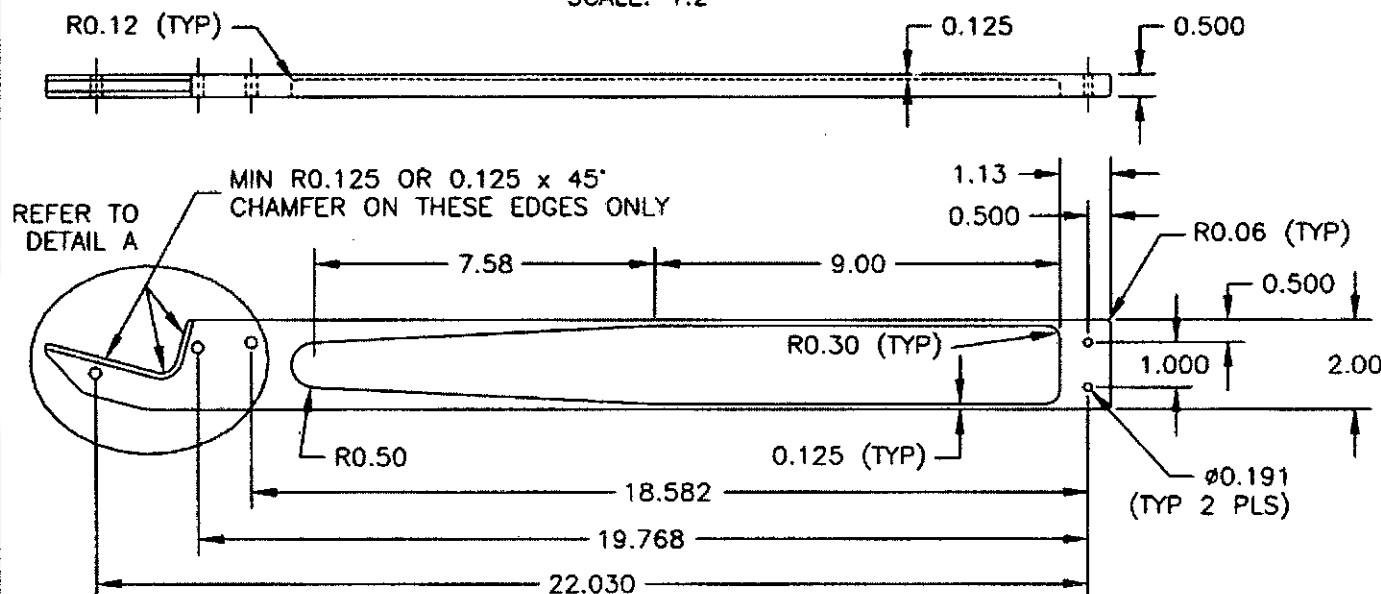
Comments: IPP C00.11.01Removed P/O for Powder Coat - in house processEC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2695-2 Leg		Manufactured	No				Each	1.0000		1			
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				Mezz			1						
				15057			1						



**DART****RELEASED**  
49.11.19

**DETAIL A**  
SCALE: 1:2



**D2695-1 LEFT HAND (SHOWN)**  
**D2695-2 RIGHT HAND (OPPOSITE)**

NOTE: DEBURR ALL EDGES R0.03 - R0.06  
MATERIAL: 6061-T6 OR 6061-T651 (QQ-A-225/8 OR QQ-A-200/8 OR QQ-A-250/11)  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1  
POWDER COAT PER DART QSI 005 4.3 WHITE (4.3.5.1) OR  
GREY SANDTEX (4.3.5.6) OR BLACK SANDTEX (4.3.5.7)

DESIGN	DRAWN	DART AEROSPACE LTD
CHECKED <i>KE</i>	APPROVED <i>KE</i>	HAWKESBURY, ONTARIO, CANADA
DATE 99.11.03	TITLE STA 84 LEG	REV. C
A	97.09.10	NEW ISSUE
B	99.10.20	UPDATE TOLERANCE, DELETE ENGRAVING
C	99.11.03	CHANGED GEOMETRY IN DETAIL A ADDED FINISH
	SCALE 1:4	SHEET 1 OF 1

